

D2563

Work Order ID 54893



Page 1

January 5, 2010 8:35:41 AM

Item ID: D205-633-017

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Standard Low Gear

Stop



Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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N/A	Rev N/A
-----	---------

100



DOCUMENT CONTROL

0.00

for BG 10/01/25

DC



Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D205-633-017CHG001

110

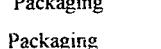


Pick Kit

0.00

10-1-25 (2x) SL

Packaging



Packaging

Memo

0.00

120



QC4- 100% Inspect kits for completeness

0.00

2) 8/10/126

QC



Quality Control

Memo

0.00

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54893

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January 5, 2010 8:35:41 AM

Item ID: D205-633-017

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Standard Low Gear

Stop



Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

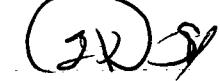
130



Packaging

0.00

10-1-26



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-633-017 Location: 70 PPP Rev: 05

140



QC21- Final Inspection - Work Order Release

0.00

10/01/27 J

QC

Memo

0.00

Quality Control

W 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear



Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Spec Qty ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-14A	61	Purchased	No			110	Each	471.0000	2.0000		10-1-25	81

Sp

Bolt

Warehouse

Location

Main Warehouse

ST

113359

Loc Qty

Loc Code

471

471

110 Each 155.0000 4.0000

2

10-1-25

81 2X

AN4-5A 42

Purchased

No

Warehouse

Location

Main Warehouse

ST

100089
106605
108672
109061
110844
111650
112933

Loc Qty

Loc Code

155

6

6

1

9

30

3

100

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893



Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rearie \$ ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-6A <i>42</i>		Purchased		No		110	Each	1,567.000	4.0000		<i>10-1-25</i>	<i>sf</i>

Sp

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	1567	
112314	167	<i>4</i>
112641	100	
112720	100	
112829	300	
112933	300	
113149	600	

AN4-7A *42*

Purchased No 110 Each 317.0000 4.0000

*10-1-25**sf**Sp*

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Main Warehouse

ST	317	
112794	1	<i>1</i>
113226	316	<i>3</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893



Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

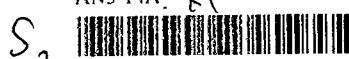
Required Date: 18/01/2010

Comments:

Start Qty: 2.00

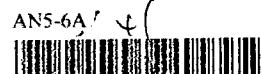
Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ANS-14A		Purchased	No			110	Each	109.0000	2.0000		10-1-25	SP

S2
BoltWarehouseLocation

Main Warehouse

ST	109	
106166	8	
112411	40	
112467	11	
112489	50	

S2
Bolt

Purchased No 110 Each 80.0000 2.0000



10-1-25

SP

WarehouseLocation

Main Warehouse

ST	80	
108376	8	
111425	22	
112243	50	

10-1-25

SP 2x

January 5, 2010 8:35:46 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Werk Order ID: 54893

Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			110	Each	1,489.000	30.0000		10-1-25	sf



Washer

Warehouse

Location

Main Warehouse

ST	1489	
103691	20	
104215	6	
108161	329	
110523	340	
111279	101	
111916	482	
112314	211	30
16941	0	

AN960JD516



Purchased

No

110

Each

655.0000 8.0000



1113288

10-1-25

sf

Washer

NAS1149005631

QSI 017 sf

Warehouse

Location

Main Warehouse

ST	655	
110363	46	
110523	57	
111279	39	
112082	64	
112314	14	
112828	28	
113149	407	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Req ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2021-101 41



Eyebolt

Manufactured

No

110

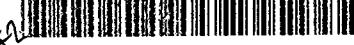
Each

11.0000

2.0000

10-1-25 sf

D2022-101 42



Spacer

Manufactured

No

ST

40433

110

Each

466.0000

4.0000

2

10-1-25 sf

D2022-103 42



Spacer

Manufactured

No

ST504

45885

50746

52325

466

266

100

100

4

10-1-25

20 sf

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893



Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2562-007

Manufactured

No

110

Each

6.0000

2.0000

10-1-25

SP

5
42Strut

Warehouse

Location

Main Warehouse

ST

47178

Loc Qty

Loc Code

6

6

Each

0.0000

2.0000

2

D2563

Manufactured

No

110

Each

0.0000

2

1 Step Weldment Assembly

D2565-401

Manufactured

No

110

Each

5.0000

2

354896 10-1-26 SP

8
42 Strut

Warehouse

Location

Main Warehouse

ST

51564

Loc Qty

Loc Code

5

5

Each

5.0000

2

D2565-403

Manufactured

No

110

Each

5.0000

2

S
42 Strut

Warehouse

Location

Main Warehouse

ST

47179

Loc Qty

Loc Code

5

5

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893



Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2565-405



Manufactured

No

110

Each

5.0000

2.0000

10-1-25

sf

S
+2 Strut

Warehouse

Location

Main Warehouse

ST

47180

Loc Qty

Loc Code

5

5

110

Each

5.0000

2.0000

2

D2565-407



Manufactured

No

Warehouse

Location

Main Warehouse

ST

47181

Loc Qty

Loc Code

5

5

110

Each

26.0000

2.0000

2

D2565-409



Manufactured

No

Warehouse

Location

Main Warehouse

ST

37394

Loc Qty

Loc Code

26

8

47831

10

47899

8

2

S
+1 Strut

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 8:35:46 AM

Work Order ID: 54893

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Comments:

Component Item ID/
Item Name  Replacement Item ID Mfg/
Purch

D2565-411  Manufactured



Start Date: 05/01/2010

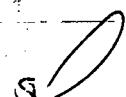
Required Date: 18/01/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Locate Sq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2565-411  Manufactured

No	110	Each	5.0000	2.0000		10-1-25	
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S+2 Strut 

Warehouse
Location

Main Warehouse

ST	5		2
47182	5		

MS21042L4  Purchased

No	110	Each	4,161.000	16.0000		10-1-25	
----	-----	------	-----------	---------	---	---------	---

Warehouse
Location

Main Warehouse

ST	4161		
102552	6		
104248	6		
110507	184		
111827	2965		76
113422	1000		
15924	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 5, 2010 8:35:46 AM

Work Order ID: 54893

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Set ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5	12	Purchased	No			110	Each	1.043.000	4.0000		10-1-25	SK (2x)

S
+2 Nut

Warehouse	Loc Qty	Loc Code
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Location

Main Warehouse

ST	1043	
110382	10	
111636	11	
112314	522	
113523	300	
113537	200	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5
5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
		1		D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
		1		D2565-201	STRUT
		1		D2565-203	STRUT
		1		D2565-205	STRUT
		1		D2565-207	STRUT
		1		D2565-209	STRUT
		1		D2565-211	STRUT
			1	D2565-301	STRUT
			1	D2565-303	STRUT
			1	D2565-305	STRUT
			1	D2565-307	STRUT
			1	D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
1	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)